

Work Order ID 70234

Wednesday, June 01, 2011 12:39:51 PM

Page 1

Item ID: D350-589-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Side Door Latch Modification

Start Date: 6/1/2011 Start Qty: 3.00

Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-01 Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
INN-D350-589	E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

8/10/06/06

HJ for CL 11-6-02

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/06 (3)

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/06/06

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 6/1/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per QSI 014

Reof
See 22

44/6/6

34

130

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

u/bh

mf

11-06-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 70234

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification





Start Date: 6/1/2011

Required Date: 6/15/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S23 AN960JD10 	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	9			
Washer													
S23 D2237 		Manufactured	No			105	Each	46.0000	3	9			
Striker Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		46							
				66139		46							
S23 D2583 		Manufactured	No			105	Each	31.0000	3	9			
Latch Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		31							
				69512		31							
S23 D2585 		Manufactured	No			105	Each	49.0000	3	9			
Mounting Channel													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		49							
				66142		19							
				69536		30							

1116583

9
9
SL

9
9
1116 SL 30

9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70234

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/1/2011

Required Date: 6/15/2011

Start Qty: 3.00

Required Qty: 3.00

D2586

Manufactured No

105

Each

81.0000

3

9



Door Latch

Location

Loc Qty

Loc Code

ST204

81

64774

81

D2587

Manufactured No

105

Each

22.0000

1



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

22

66836

22

D2589

Manufactured No

105

Each

101.0000

1



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

101

58194

101

MS20470AD4-5

Purchased No

105

Each

1,078.000

6

18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1078

116893

1078

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Wednesday, June 01, 2011 12:39:46 PM

Work Order ID: 70234



Parent Item: D350-589-011



Parent Item Name: Side Door Latch Modification

Start Date: 6/1/2011

Required Date: 6/15/2011

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

105

Each

2,573.000

3

9



SP

Nut

Location

Loc Qty

Loc Code

ST300

2573

116391

11

116540

96

116549

766

117441

800

117601

400

117885

500

9

MS27039-1-15

Purchased

No

105

Each

74.0000

3

9



116162 (32)

Screw

Location

Loc Qty

Loc Code

ST292

74

116916

74

9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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